

Work Order ID 48366

Friday, June 26, 2009 9:03:00 AM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 7/15/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Sork/24

09/07/23

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld
Fwd End Plate as per QSI 004 & Dwg D3272 A/RAluminum
Rod M110130 3-Grind End Plate flush
M110972

09.01.15

10

120

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

09.07.16

Work Order ID 48366

Friday, June 26, 2009 9:03:00 AM



Page 2

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 7/15/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

27 8 01/07/16

4104 0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

BR 09-07-16 10 L/H



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

PH 09-07-16 10



QC

Memo

0.00

Quality Control

Work Order ID 48366

Friday, June 26, 2009 9:03:00 AM

Page 3

Item ID: D350-591-312

Accept

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 7/15/2009 Start Qty: 10.00

Required Date: 8/3/2009 Req'd Qty: 10.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Assemble Leg Assembly as per Dwg D3272.								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
180 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Bevel Aft end for welding <input type="checkbox"/> 2-Inspect for foreign object as per QSI 024 <input type="checkbox"/> 3- Weld Aft End Plate as per QSI 004 & Dwg D3272 <input type="checkbox"/> A/RAluminum Rod <u>M110130</u> <input type="checkbox"/> 4-Grind End Plate flush <input type="checkbox"/> 5-Install last rivet.								

Work Order ID 48366

Friday, June 26, 2009 9:03:00 AM



Page 4

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 7/15/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00

AD

09.07.17



QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

=>

S 09/07/17

(X1027) 4



QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

ump 09/07/20

(X10)



HandFinish

Memo

0.00

Hand Finishing

Work Order ID 48366

Friday, June 26, 2009 9:03:00 AM



Page 5

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 7/15/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 112148

0.00

BL 09-07-21 (10)

Powder Coating

Memo

START TIME:

3:45

OVEN TEMPERATURE:

3200 FINISH TIME:

4:15

230

Pressure Wash per QSI005 4.3

0.00



HandFinish

Wing Walk

Memo

Batch: M 111013

0.00

WMD 09/07/23 (X12)

Hand Finishing

09/07/21

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

=> 8 09/02/24



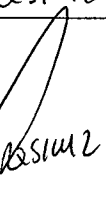
(X1024) φ

(P10) ->

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-591-312 PAR #: N/A Fault Category: Large fab. NCR: Yes No DQA: NA Date: 09-07-28
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: NA Date: 09-08-15

NCR: <u>48366</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/22	Found @ Step 240	During QC3 Powdercoat inspection it was found that some welding was not properly ground down on one SGO (see		- Buff as usual. sand smooth - Touch-up with white primer per Q5102 - Do not Mask off step 2 - Re-powdercoat the affected areas	09-07-28 09-07-28 09-07-28	S 09/07/22	LSIUM2	S 9/7/22
		(Left end). Found on after P.L and wing walk. R.L missed at welding inspection and missed at QC5. Lack of attention		Ensure surface is smooth prior to powder coating	09-07-28			
		 weld not ground here NOT END					LSIUM2	

NOTE: Date & initial all entries

[illegible]

Friday, June 26, 2009 9:03:00 AM

Accept

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives of the project. These objectives should be clear, measurable, and achievable.

3. The third step is to develop a plan of action. This involves determining the steps that need to be taken to achieve the objectives and assigning responsibilities to team members.

4. The fourth step is to implement the plan. This involves carrying out the tasks and activities that have been planned.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes with the objectives and identifying any areas for improvement.

Setup Start[illegible]

Stop

[illegible]**Cust Item ID:**

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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Customer:

Reference:

Run Start

1. The first step is to identify the problem. In this case, the problem is that the company is not meeting its sales targets.

Stop

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. Finally, the fifth step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and goals and identifying any areas for improvement.

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

[illegible]

Packaging

Memo

0.00

Packaging

QC4- 100% Inspect kits for completeness

0.00

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. The second step is to define the objectives and goals of the project. This involves determining what you want to achieve and how you will measure success.

3. The third step is to develop a plan of action. This involves identifying the steps that need to be taken to achieve the objectives and goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.

5. The fifth step is to evaluate the results. This involves assessing the outcomes of the project and determining whether the objectives and goals have been achieved.

6. The sixth step is to report on the results. This involves communicating the findings of the project to the relevant stakeholders.

7. The seventh step is to review the process. This involves reflecting on the project and identifying areas for improvement.

8. The eighth step is to share the results. This involves disseminating the findings of the project to a wider audience.

9. The ninth step is to celebrate success. This involves acknowledging the achievements of the project and the team.

10. The tenth step is to learn from the experience. This involves reflecting on the project and identifying lessons learned for future projects.

QC

Memo

0.00

Quality Control

Packaging

0.00

[illegible]

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-312 ☐ Location: 15

Work Order ID 48366

Friday, June 26, 2009 9:03:00 AM



Page 7

Item ID: D350-591-312**Accept****Setup Start****Revision ID:** B**Stop****Item Name:** Heli-Access-Step, Long RH**Start Date:** 7/15/2009 **Start Qty:** 10.00**Cust Item ID:****Required Date:** 8/3/2009 **Req'd Qty:** 10.00**Customer:****Reference:****Run Start****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Stop****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/28

W 87-07-27-

Picklist Print

Page 1

Friday, June 26, 2009 9:03:00 AM

Work Order ID: 48366

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3067-1RevA 		Manufactured	No			110	Each	0.0000	10.0000			
End Plate												
✓ D3272-1RevB 		Manufactured	No			110	Each	0.0000	10.0000			
Step												
✓ MS21042L5 		Purchased	No			110	Each	0.0000	20.0000			
Nut												
✓ D3065-041RevB 		Manufactured	No			160	Each	0.0000	10.0000			
Step Leg Assembly Hi												
✓ D3066-1RevB 		Manufactured	No			160	Each	0.0000	20.0000			
Spacer												
✓ D3219-1RevA 		Manufactured	No			160	Each	0.0000	20.0000			
Plate												
✓ MS20600-AD4W4 		Purchased	No			180	Each	0.0000	160.0000			
Rivets												
✓ AN3-35A 		Purchased	No			260	Each	2 0.0000	20.0000			
Bolt												
✓ AN4-13A 		Purchased	No			260	Each	8 0.0000	80.0000			
Bolt												

3 48242 *PK*

3 48416 *PK*

M111127 *SP*

* 3 47090 *PK*

* 3 47185 = 11 3 48414 = 9 *PK*

* 3 47296 *PK*

* 3 M111477 *PK*

M110467 *SP*

M111925 *SP*

(10x)

9/7/24

9/7/24

9/7/24

40

40

40

Friday, June 26, 2009 9:03:00 AM

Work Order ID: 48366

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:**Start Date:** 7/15/2009**Required Date: 8/3/2009****Start Qty: 10.00**

Required Qty: 10.00

[illegible]

Friday, June 26, 2009 9:03:00 AM

Shop Packet Print

Date: Wednesday, 03/06/2009 10:50:25 AM
 User: Julie Dawson

Process Sheet

Customer	: CC-EUR01 Eurocopter France	Drawing Name	: LONG STEP ASSEMBLY HIGH SKID RH
Job Number	: 48366		
Estimate Number	: 13561		
P.O. Number	:	Part Number	: D350591312
This Issue	: 03/06/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3272 REV-B-EUROCOPTER
First Issue	: / /	Project Number	: N/A
Previous Run	: 47860	Drawing Revision	: B
	Type	Material	:
	: LARGE FAB ASSY	Due Date	: 26/06/2009
Written By	:	Qty:	10
Checked & Approved By	: <u>JLD 09.06.03</u>	Um:	Each
Comment	: Est Rev:A 04.03.22 New issue KJ/RF Est Rev:B 07-06-09 Added D3572-1 JLM Est. returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0 ✓ DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

2.0 ✓ D32721

Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

STEP

BATCH: 348416
11.09.07.15 10

3.0 ✓ D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate 348242
11.09.07.15 10

4.0 ✓ D32191

Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3219-1

Support 347296
11.09.07.15 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:50:25 AM
User: Julie Dawson

Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 48366

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 ✓ LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M110130
M110912

3-Grind End Plate flush

PE 09.07.15 10

PE 09.07.15 10

PE 09.07.15 10

6.0 ✓ QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.07.16 (10)

7.0 ✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.07.16 (10) (10) (10)

8.0 ✓ HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0 ✓ QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PE 09.07.16 10

10.0 ✓ D3065041

Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3065-041 Step Leg Assy

11.0 ✓ D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3066-1 Spacer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:50:25 AM
User: Julie Dawson

Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 48366

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0



MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 MS20600AD4W4 Rivet _____

13.0



LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

14.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate _____

16.0



LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272.

A/R Aluminum Rod _____

4-Grind End Plate flush

5-Install last rivet.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:50:26 AM
User: Julie Dawson

Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 48366

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0



QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

18.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sorter 17 *NO RM*

19.0



HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

20.0



POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

21.0



HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

22.0



QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

23.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0



D22303

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:50:26 AM
User: Julie Dawson

Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 48366

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

✓ D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618 Bushing

26.0

✓ D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Abrasion Strip

2 x D2856-400-720

27.0

✓ D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1 Mounting Lug

28.0

✓ D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041 Support Assembly

29.0

✓ AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt

30.0

✓ AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:50:26 AM
User: Julie Dawson

Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 48366

Part Number: D350591312

Job Number:



Seq. #: Machine Or Operation: Description :

31.0 ✓ AN536A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A Bolt

32.0 ✓ AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer

33.0 ✓ AN960JD416 Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer

34.0 ✓ AN960JD516 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

35.0 ✓ MS21042L3 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:50:26 AM
User: Julie Dawson

Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 48366

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0



MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4) _____

37.0



MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) _____

38.0



QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

39.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-312

Location: _____

40.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07 06 04 - H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

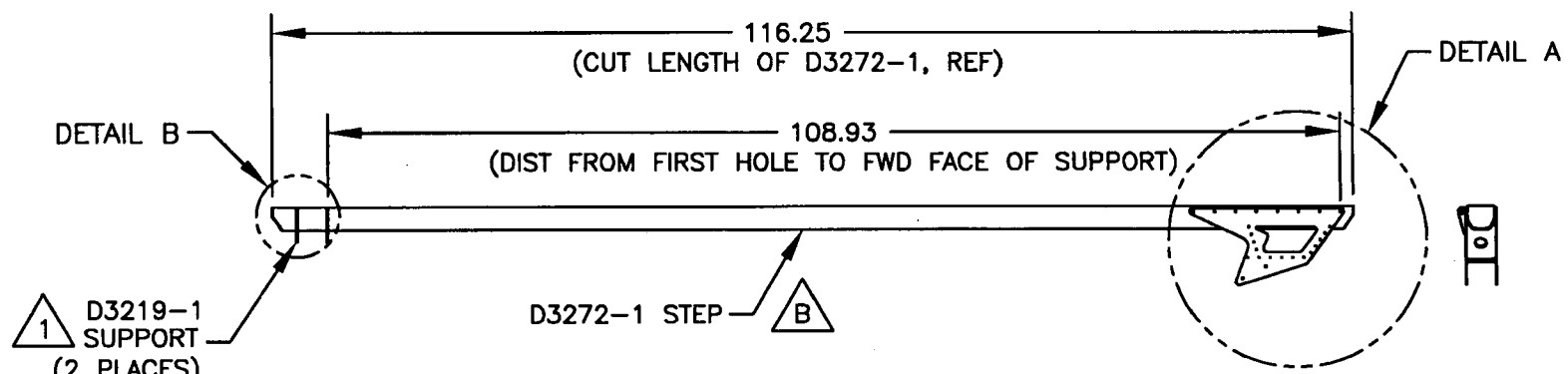
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WORK ORDER
NO. *48366*

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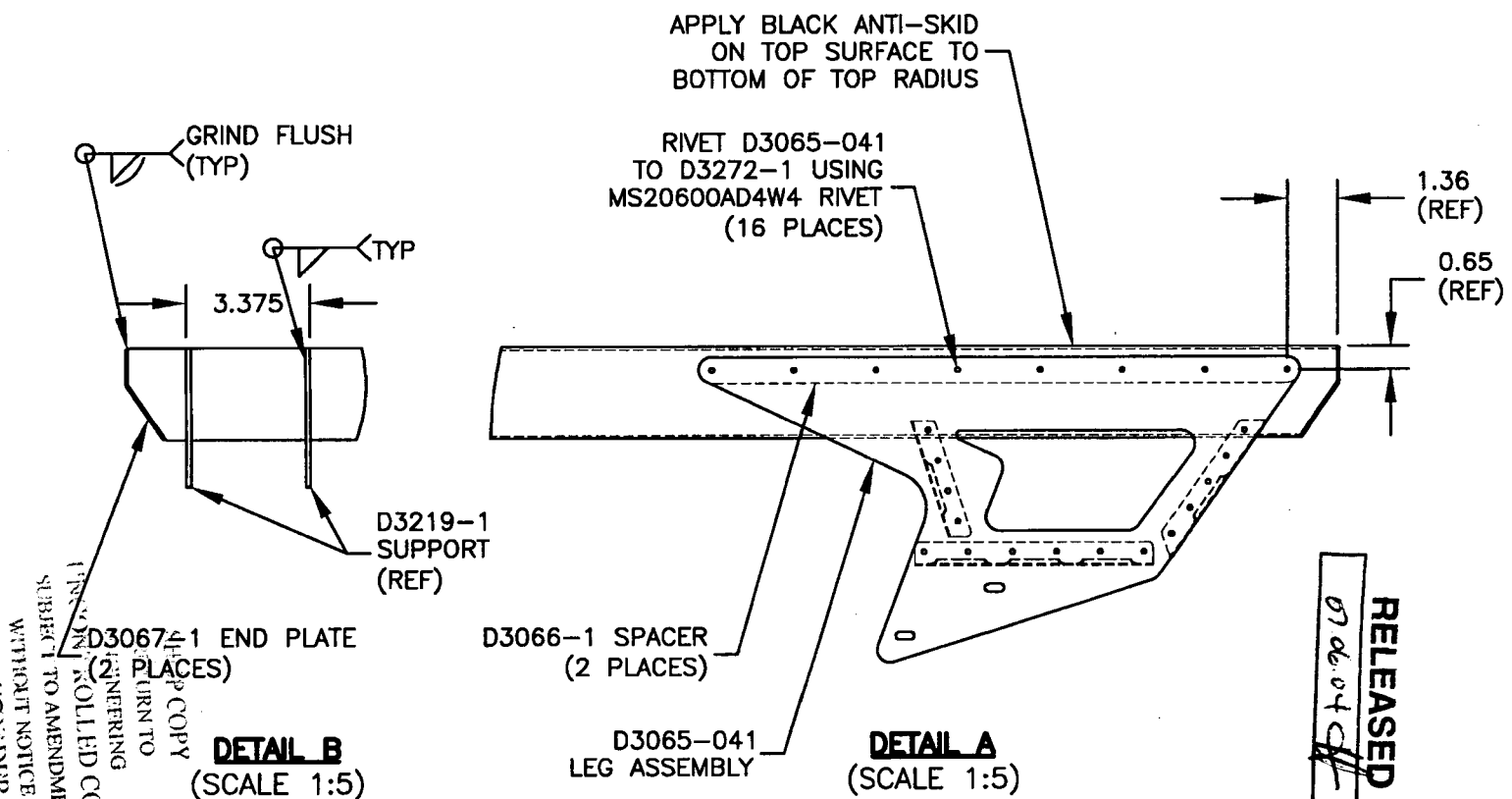
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CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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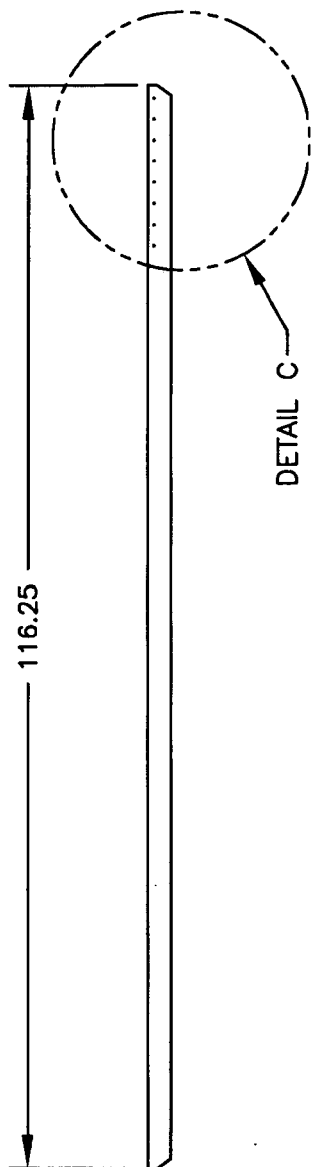
NO 48368



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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

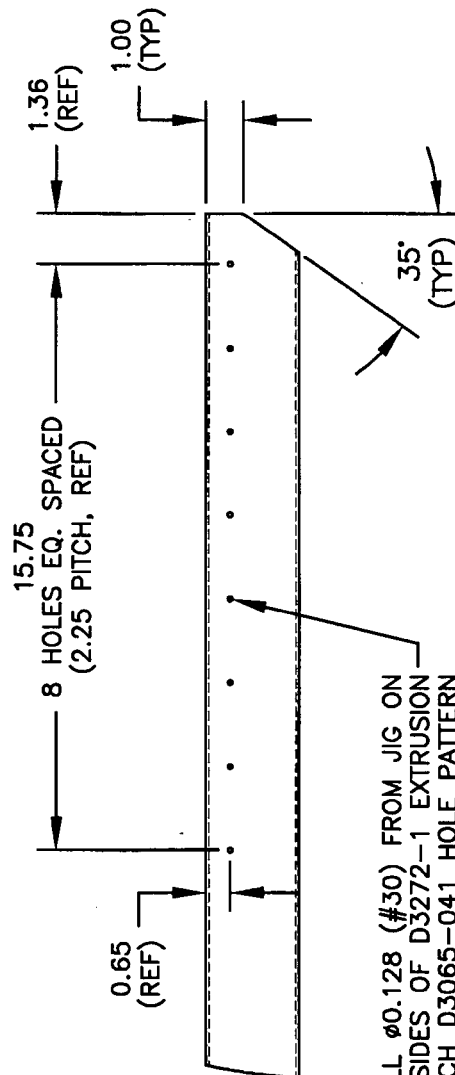
RELEASED

07.06.04 [Signature]



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE: 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN
COPY
JRN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48366

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.